

Work Order ID 151707

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Item ID: D2939-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle RH In, 206
Start Date: 9/23/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 10/7/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.01				4			2/16-11-16
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.05				(X4)			2016/11/16 BEB
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M 134798 Memo START TIME: 3:20 OVEN TEMPERATURE: 320° FINISH TIME: 3:50	0.00 0.02				4	φ	16-11-17	DAS 34 9:89

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							DAS 38 9-89
160						4			
QC	Memo	0.01							
Quality Control									NOV 18 2016
170	Identify as per dwg & Stock Location: <u>Steger</u>	0.00							
170						4			NOV 18 2016
Packaging	Memo	0.01							DAS 6 9-89
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							DAS 21 9-89
180									NOV 18 2016
QC	Memo	0.07							
Quality Control									DAS 21 9-89 NOV 18 2016

Picklist Print

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Work Order ID: 151707

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Parent Item: D2939-2

D2939-2

Parent Item Name: Saddle RH In, 206

Start Date: 9/23/2016

Required Date: 10/7/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	27.0000	1	4			

D6101-001

Saddle Billet

Location	Loc Qty	Loc Code
MAT042	27	
145262	6	
<u>147677</u>	9	
150689	12	

4

DAS
45 16-10-31
9-89

DART AEROSPACE LTD				Work Order: 151707	
Description: 206 Saddle, Inboard, Right side				Part Number: D2939-2	
Inspection Dwg: D2939 Rev: C DSK: Rev:				Page 1 of 1	

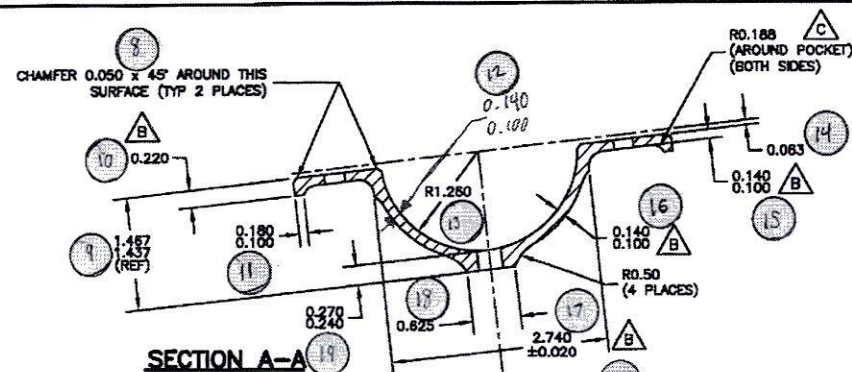
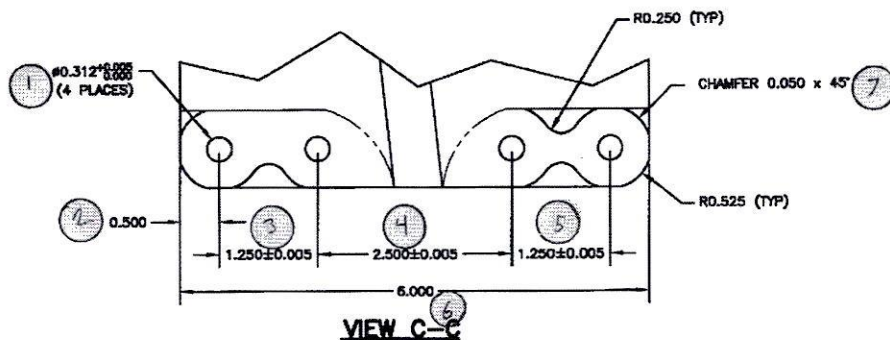
FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.100	0.140		0.113	0.114	0.114	0.113	
B	0.100	0.140		0.116	0.116	0.117	0.114	
C	0.100	0.140		0.114	0.115	0.113	0.113	
D	0.210	0.230		0.220	0.220	0.220	0.220	
E	1.245	1.255		1.250	1.250	1.250	1.250	
F	1.245	1.255		1.250	1.250	1.250	1.250	
G	2.495	2.505		2.500	2.500	2.500	2.500	
H	0.510	0.515		0.513	0.513	0.513	0.513	
I	1.572	1.582		1.577	1.577	1.577	1.577	
J	2.495	2.505		2.500	2.500	2.500	2.500	
K	0.257	0.262		0.258	0.258	0.258	0.258	
L	0.312	0.317		0.314	0.314	0.314	0.314	
M	0.235	0.240		0.236	0.235	0.235	0.236	
N	0.100	0.140		0.120	0.120	0.120	0.120	
O	0.540	0.560		0.552	0.552	0.552	0.552	
P	0.490	0.510		0.497	0.501	0.498	0.498	
Q	3.715	3.725		3.720	3.720	3.720	3.720	
R	2.720	2.760		2.740	2.740	2.740	2.740	
S	0.240	0.270		0.259	0.259	0.259	0.259	
T	0.100	0.180		0.128	0.128	0.128	0.128	
U	1.625	1.635		1.630	1.630	1.630	1.630	
V	1.362	1.372		1.367	1.367	1.367	1.367	
W	0.316	0.321		0.316	0.316	0.316	0.316	
X	1.250	1.270		1.260	1.260	1.260	1.260	
Y	1.565	1.585		1.575	1.575	1.575	1.575	
Z	0.178	0.198		0.188	0.188	0.188	0.188	
AA								
AB								
AC								
AD								
Accept/Reject								

Measured by: B. 08	Date: 16-11-15
Audited by: JL 16-11-16	Date: 16-11-16
Prototype Approval: N/A	Date: N/A

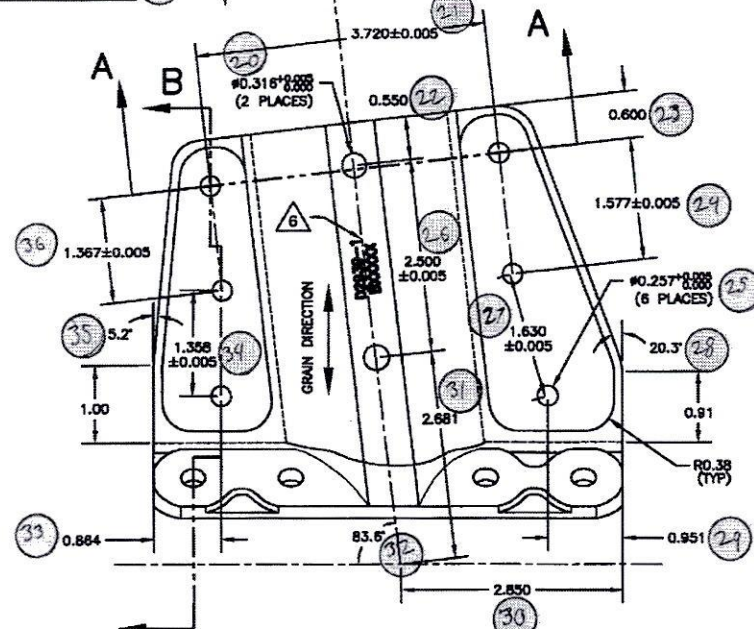
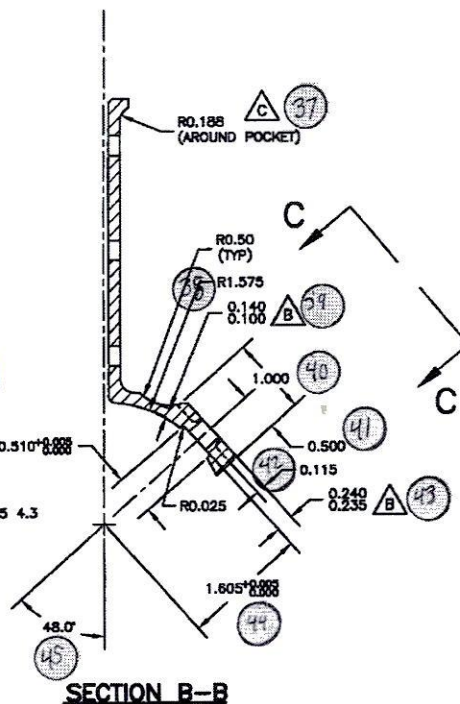
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	



D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 151707

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (00-A-250/12)
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	4	DART DART AEROSPACE USA, INC.
CHECKED	PH	DRAWING NO. 02939
DATE	06.11.09	TITLE SADDLE INSIDE
		REV. C SHEET 1 OF 1 SCALE 2:3

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01.02.12